



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

9293

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		19310 ✓	50/50
2	Machined By		V.T.L. M/C Shop	Dry No. 18.02 53
3	Pallet Die No.		14660 (B.O) M/C	Rev. 02 00
4	Die Category	Drg. No.	Senior (A32)	
5	Out Side Diameter	Drg. No.	520 mm Step 00. 491 mm	Step length 16.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	160 mm	
8	Grooves as per Drawing	Drg. No.	12 x 9 x 3 mm 12 x 9 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping w/ of Holes & Bolt Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		03/4" Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.2 mm Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/7/13

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter Go Ravi 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5 mm	Outside (2-2)	Inner			
3	External Relief Depth		5 mm	Nil			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Shri Keshav				
6	Material Sent For Hardening On Date		27	8	25		

Inspected By (Sign) & Date

Ravi 27/7/13

Reviewed by (Engineer-CNC)

Manager-QA